Each

Dart Aerospace Ltd. Thursday, 16/08/2007 10:23:06 AM Linda Lacelle User **Process Sheet** : LUG **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Jok Number : 33997 : 10337 **Estimate Number** : D28073 NL: Part Number P.C. Number : 16/08/2007 S.O. No. : NIA **Drawing Number** - D2807 REV C This Issue : N/A **Project Number** Prsht Rev. : MACHINED PARTS **Drawing Revision** First Issue : 32801 Material **Previous Run** : 05/09/2007 80 Um: Due Date Qty: Written By **Checked & Approved By** : Est A 05.06.02 Comment **Additional Product** Jot Number: Description: Seq. #: 303 Round Bar .75" M303R0750 1.0 Comment: Qty.: 0.1094 f(s)/Unit Total: 8.7528 f(s) Material: 303 Round Bar Ø0.750" (M303R0.750) HARDINGE 2.0 Comment: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev: 2-Deburr 3.0

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HAAS CNC VERTICAL MACHINING #

Comment: Haas #1

4.0

HAAS1

Machine as per Folio FA528 and Dwg D2807 Dwg Rev:

Folio Rev: AA

2-Deburr

mozh /12



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W/O:		WORK ORDER CHANG	ES						
DATE	STEP PROCEDURE CHANGE			STEP	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		7							
Part No		PAR #: Fault Category:	NCR: Yes	No D	QA:	_ Date: <u> </u>	3/4/14		
					sed:	_ Date: _			

CR: WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC		Corrective Action Section B		Varification	Ammanal	A
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
•					,		
	STEP	BTEP Description of NC Section A	STEP Section A Initial	STEP Section A Initial Action Description	STEP Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Section A Initial Action Description Sign & Section C Chief Eng

NOTE: Date & initial all entries

Thursday, 16/08/2007 10:23:06 AM Dat a: User: Linda Lacelle **Process Sheet Drawing Name: LUG** Customer: CU-DAR001 Dart Helicopters Services Part Number: D28073 Job Number: 33997 ob Number: Description: Seq. #: **Machine Or Operation:** INSPECT PARTS AS THEY COME OFF MACHINE 5.0 PARTS AS THEY COME OFF MACHINE Comment: INSPECT SECOND CHECK 6.0 QC8 Comment: SECOND CHECK PACKAGING RESOURCE #1 7.0 PACKAGING 1

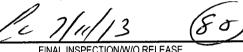


QC21

8.0

Job Completion

Comment: PACKAGING RESOURCE #1 Identify and Stock Location:





Comment: FINAL INSPECTION/W/O RELEASE



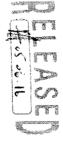
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Dart Ae	rospace L	td								
W /O:			V	VORK ORDER CH	ANGES					
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No		PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A:	Date:	
						QA: N	/C Close	d:	_ Date: _	
NCR:			WORK OR	DER NON-CONFO	RMANCE	(NCF	R)			
DATE	STEP	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Descrip	tion	Sign & Date	Secti		Chief Eng	QC Inspector
								ļ		

NOTE: Date & initial all entries







CHANGE SPRING TO SS, ADD -3 LUG	05.05.25	0
ADD FINISH	05.03.16	В
NEW ISSUE	00.11.03	A
GAS SPRING 1:1		05.05.25
TITLE SCALE		DATE
D2807 SHEET 1	#	¥
DRAWING NO. REV. C	APPROVED	CHECKED!!
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWN BY	

	0.24 TO CRIMP (TYP)
5	
	CRIMP 0.015-0.025" DEEP \ WITH Ø0.375 TOOL AT \ 2000psi (REF), TYP TWO \ SIDES PER LUG

6.46 MIN EXTENDED

4.88 MAX

COMPRESSED

D2807 GAS SPRING

1) SPECIFICATION: SS GAS SPRING

ACCEPTABLE LOAD RANGE IS 25 Ib MIN TO 45 Ib MAX

M5x0.8 THREADS

ArvinMeritor Motion Control Systems, Leicester, UK POSSIBLE SUPPLIER:

P/N: SXF6S6050080S6L-115N

(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

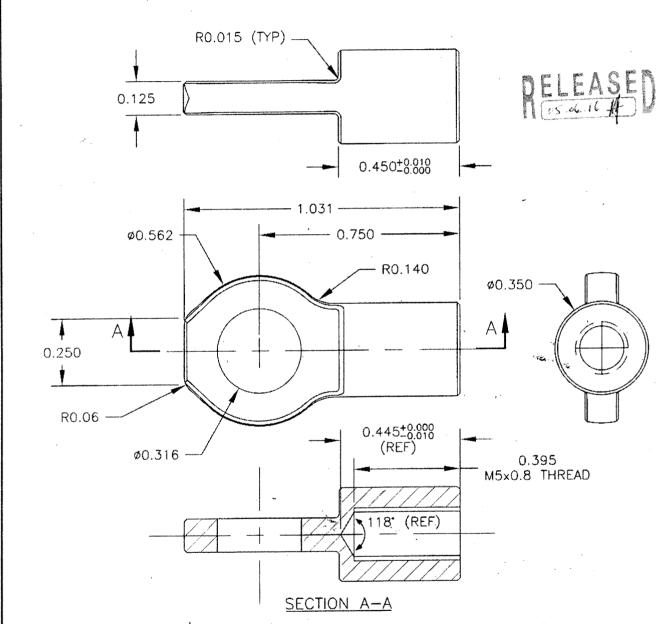
D2807-3 LUG (2 PLACES)

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN CP	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANA			
CHECKED	APPROVED 11	DRAWING NO.	A. (#* 2004)	REV	
1/1	AM	D2807	SHEET		
DATE	`	TITLE		SCA	ALE
05.05.25		GAS SPRING			3:1



D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD Work Order: 33997

Description: Lug Part Number: D2807-3

Inspection Dwg: D2807 Rev: C Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.124				
R0.015	+/-0.010	R0.020				
0.450	+0.010/-0.000					
Ø0.562	+0-008/-0.001	0.440				
1.031	+/-0.010	1.030				
0.750	+/-0.010	0.754				
R0.140	+/-0.010	R.140				
0.250	+/-0.010	- 255	_/_			
0.395	+/-0.010	,409	-			
0.445	+0.000/-0.010	0.445				
Ø0.316	+0.006/-0.001	00.317	-			
Ø0.350	+0.006/-0.001.i/	0.317	-			
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Measured by:	20 and	Audited by:	Prototype Approval:	N/A
Date:	07/09/04 84	Date: 07/09/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.08.29	New Issue	KJ/JLM	



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